

shy 30/08

Dart Aerospace Ltd.

Date: Wednesday, 29/08/2007 6:56:46 AM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 32805	
Estimate Number : 11146	
P.O. Number : <u>N/A</u>	Part Number : D32089
This Issue : 29/08/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3208 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 06/06/2007 Type : MACHINED PARTS	Drawing Revision : A1
Previous Run :	Material : <u>N/A</u>
Written By : <u>[Signature] 07-08-29</u>	Due Date : 26/06/2007 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est A04.06.09 New issue KJ/RF	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
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Comment: Qty.: 0.1516 sf(s)/Unit Total: 1.5162 sf(s)  
Material: 2024-T3 (QQ-A-250/4) 0.080" thick  
(M2024T3S.080)  
Identify for D3208-9  
Batch: M104 921 IB 07-08-29

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D3208  
Dwg Rev: A1  
Prog Rev: A1

IB 07-08-29

(24) (24)

PH

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 07-08-29

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Er 07/08/29 (x32)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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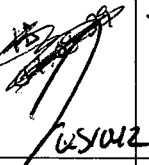
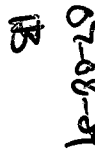

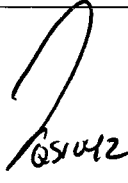
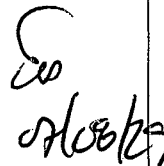
Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

John 07/08/04

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: RD Date: 07/09/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/06	#30	two (2) parts scrap due to the parts being under tol. Part ran off the edge of the sheet. <del>R.C. 005</del>	 165012	Scrap and destroy NO Replace	 16-20-20	 07/09/06	 165012	 07/09/06

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 32805

Part Number: D32089

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*M. J.* *07/09/06* **(32x)**

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*07/09/06* **(32)**

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*07/09/06* **(32)**

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/09/06* **(32)**

Job Completion



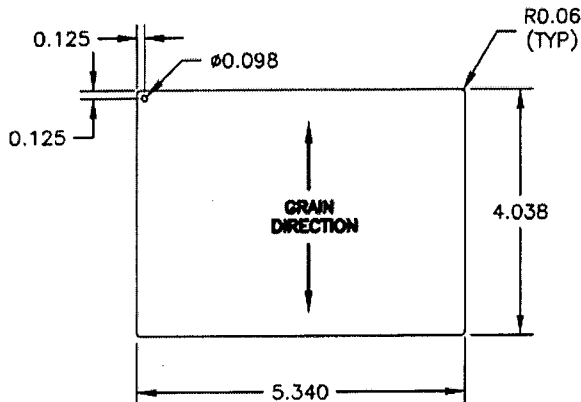
*07/09/06*



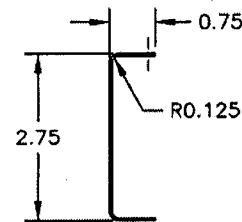


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CHECKED #	APPROVED #	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:3
A	04.01.27	NEW ISSUE	
AI	# 04.05.25	CHANGE DIM; NOTE 3) CHANGE	

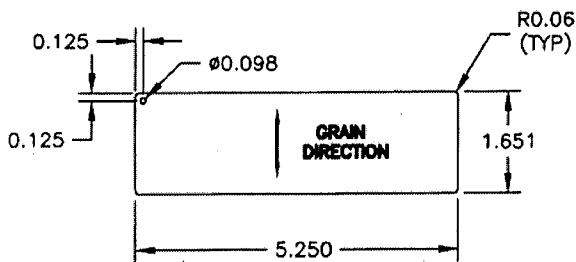
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04.04.05



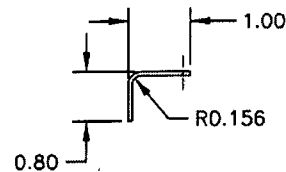
2 D3208-1 DOUBLER  
FLAT PATTERN



D3208-1 DOUBLER  
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE  
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE  
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



- 3) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063" THICK (M6061T6S.063)

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WORK ORDER  
NO. 32805

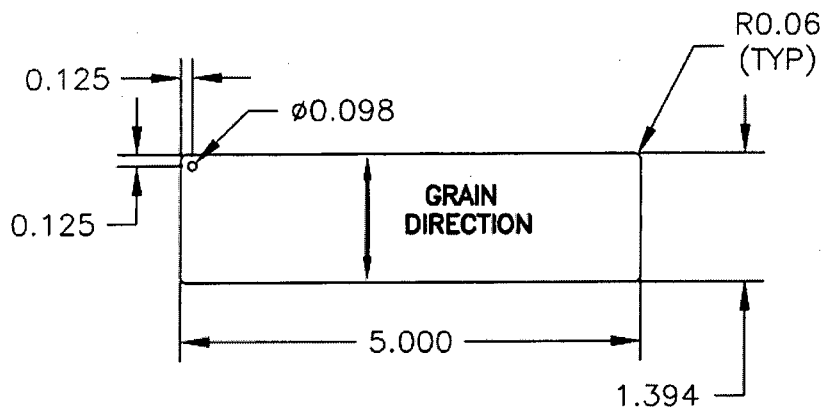
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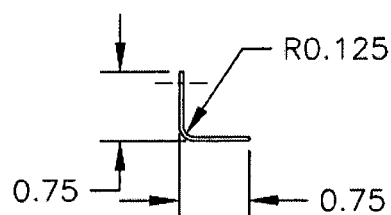


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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

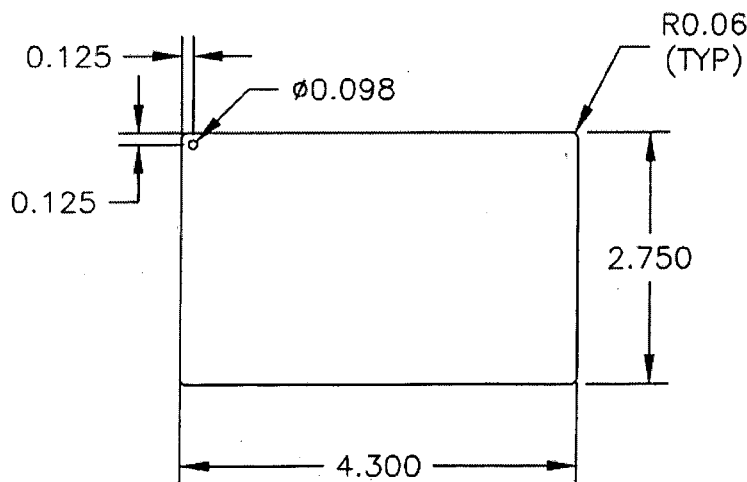
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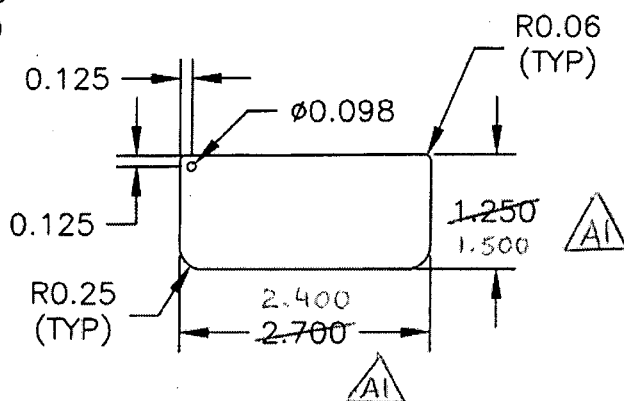
2 D3208-5 MOUNT ANGLE  
FLAT PATTERN



D3208-5 MOUNT ANGLE  
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

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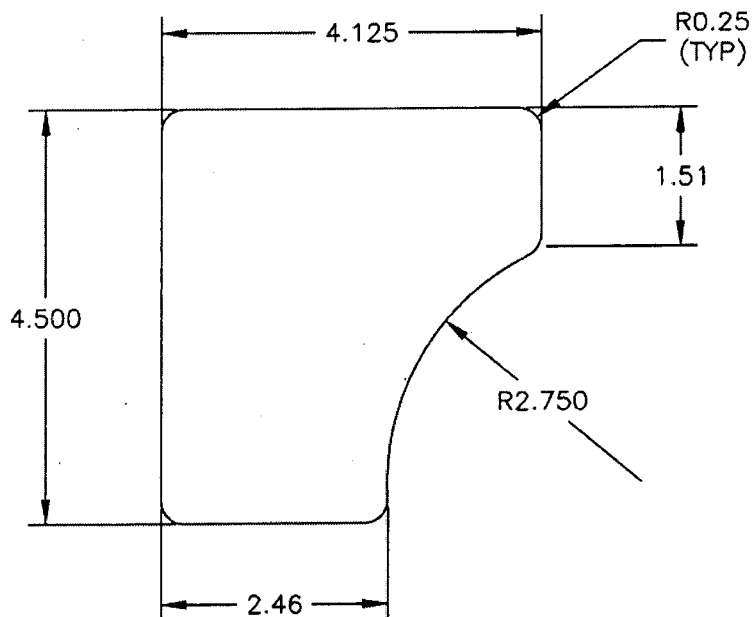
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3208	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

RELEASED  
04.04.05 off



**D3208-9 DOUBLER**

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